

ship June 30

Dart Aerospace Ltd.

Date: Monday, 6/12/2006 3:49:14 PM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STEP WELDMENT |
| Job Number | : 27534 | | |
| Estimate Number | : 10698 | | |
| P.O. Number | : NIA | Part Number | : D34631 |
| This Issue | : 6/12/2006 S.O. No. : NIA | Drawing Number | : D3463 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : NIA Type : SMALL /MED FAB | Drawing Revision | : B |
| Previous Run | : 25742 | Material | : NIA |
| Written By | : <i>SEE COMMENT BELOW</i> | Due Date | : 6/19/2006 Qty: 4 Um: Each |
| Checked & Approved By | : <i>06.06.13</i> | | |
| Comment | : EST REV. A 05.11.17 NEW ISSUE EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|---------------|-----------|
| 1.0 | M316TR100W120 | Inventory |
|-----|---------------|-----------|



Comment: Qty.: 2.1872 f(s)/Unit Total : 8.7486 f(s)
AISI 316 SS seamless tubing 1.00" OD X 0.120 wall
(M316TR1.00w120)
Batch: ~~1000~~ M100023

FF 06.06.19 4

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
Cut blank 25.00 " long

FF 06.06.19 4

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Bend as per dwg D3463

2-Trim to lenght per dwg D3463

3- Deburr

FF 06.06.19 4

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP
Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

06.06.21 4

| | | |
|-----|---------------|------------------------------|
| 5.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE
1- Drill as per dwg D3463

06/06/27 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:49:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27534

Part Number: D34631

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr as per dwg D3463

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature]

06/06/27

4

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.G

06/06/27

4

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS*

AA 06/06/27 (4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

[Signature] 06/06/27 (4)

Job Completion



U 06.06.27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

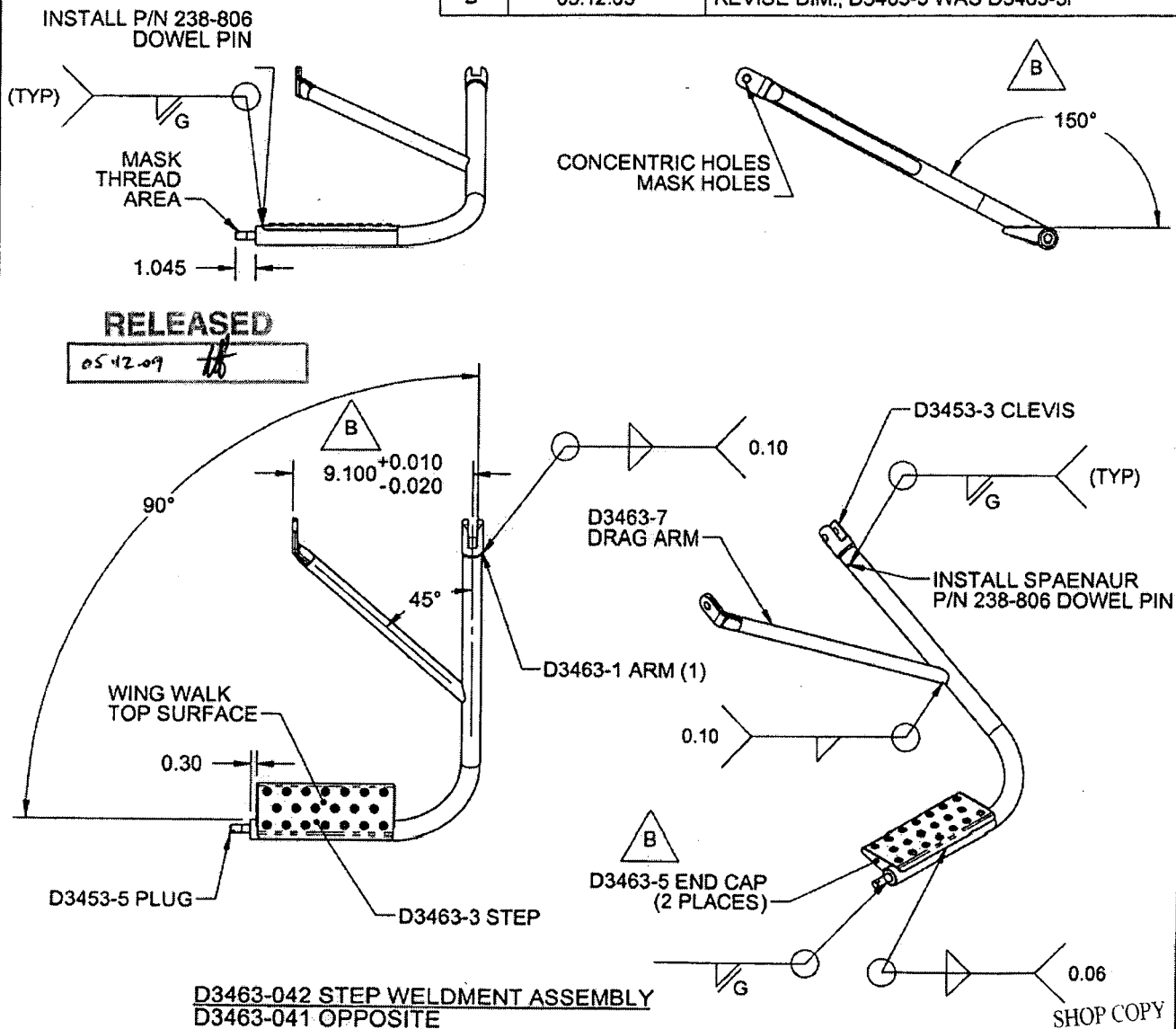
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

| | | | |
|-------------------------|-------------------------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 1 OF 4 |
| DATE 05.12.05 | TITLE STEP WELDMENT | | SCALE 1:8 |
| A | 05.09.20 | NEW ISSUE | |
| B | 05.12.05 | REVISE DIM.; D3463-5 WAS D3463-5F | |

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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NO. **27534**

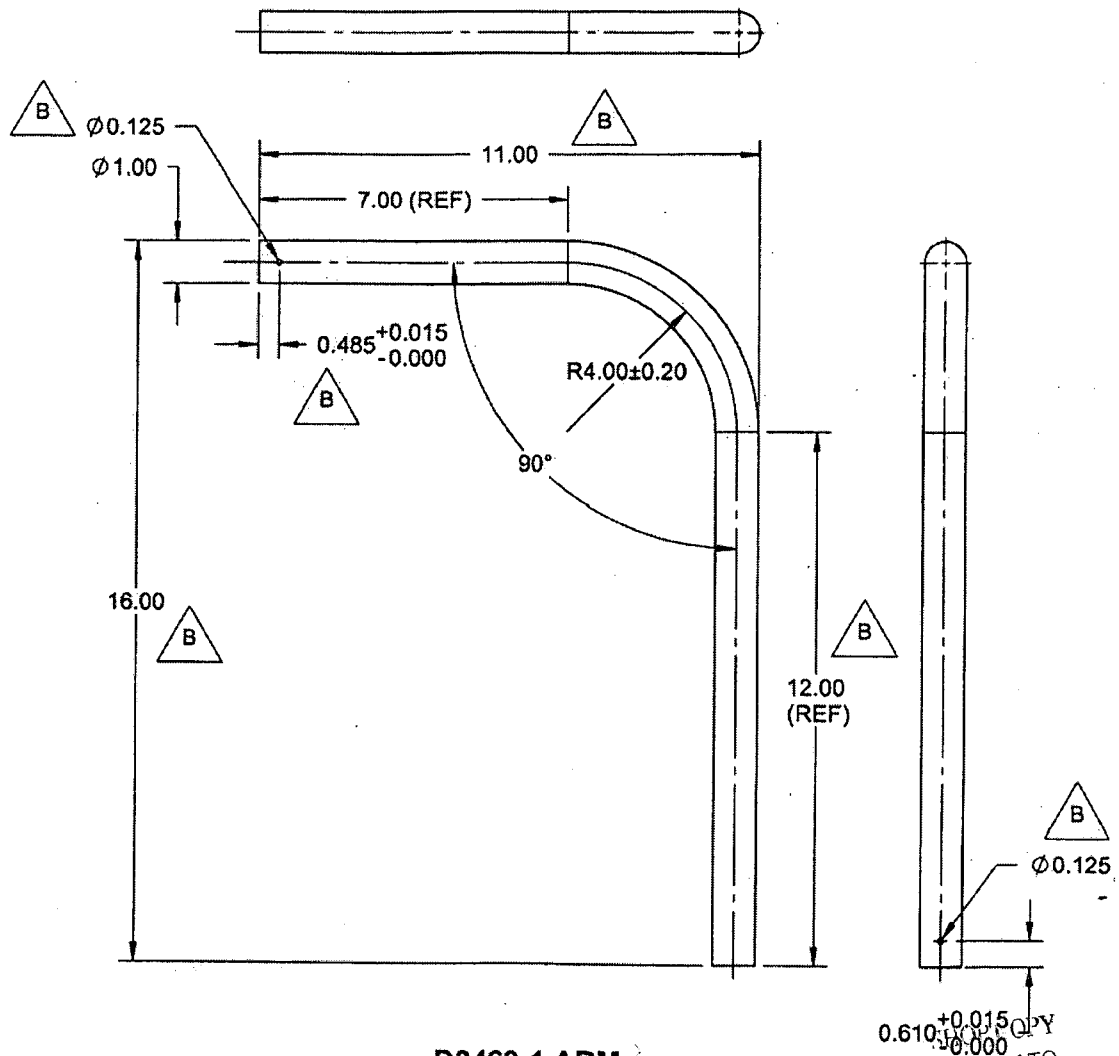
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3463 | REV. B SHEET 2 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:4 |

RELEASED



05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

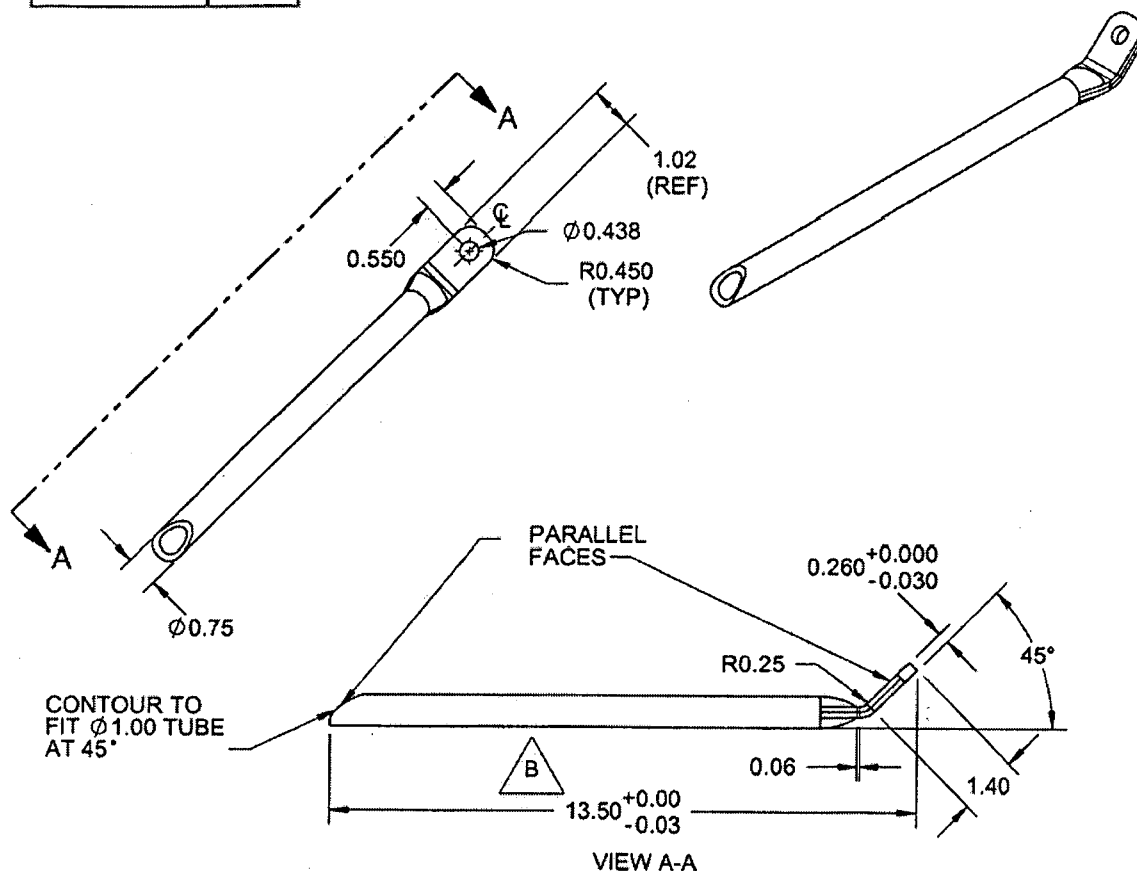
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| CHECKED  | APPROVED  | DRAWING NO. D3463 | REV. B SHEET 3 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT SCALE 1:4 | |

05.12.09 ~~11~~



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

304TR0.750W(120)

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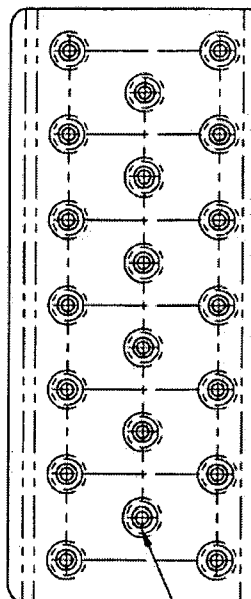
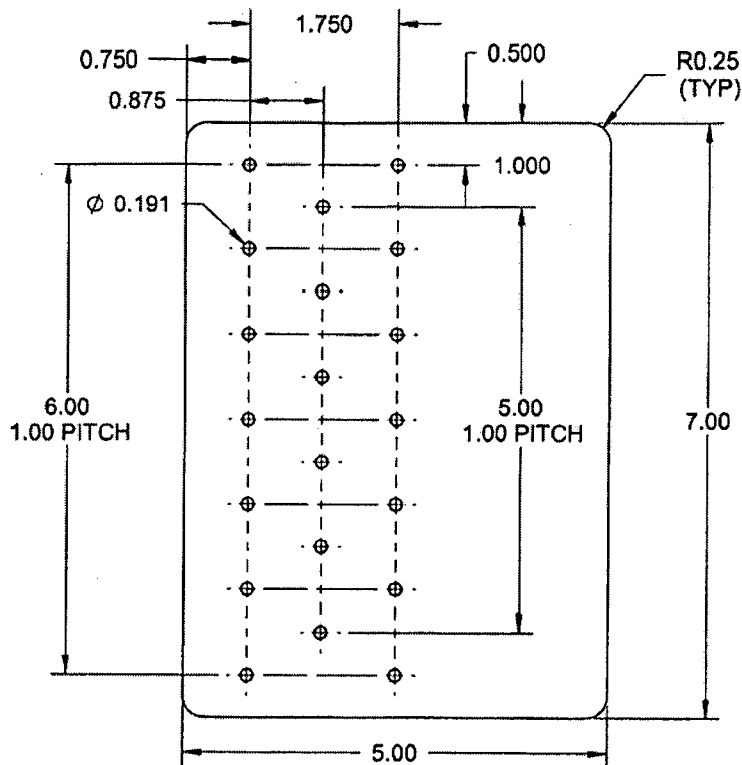
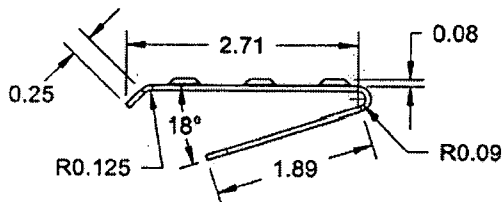
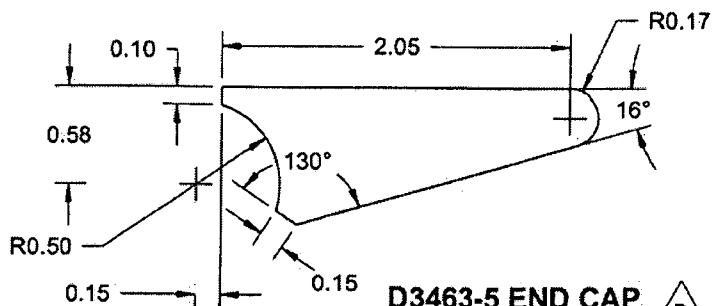
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| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 4 OF 4 |
| DATE 05.12.05 | TITLE STEP WELDMENT | | SCALE 1:2 |

RELEASED

05.12.09 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**

SCALE 1:1

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WORK ORDER

NO 27534

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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